

Work Order ID 102114

Monday, May 27, 2013 10:02:35 AM

102114

Page 1

Item ID: D4027-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hose Clamp Assembly

Start Date: 5/27/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/31/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 13-5-27

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4027

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Drill hole and assemble as per dwg notes
3M Countact adhesive batch: *M124297*

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

2420

43/0/28 (4)

ff 13-05-28

430 228 BS28

4 0

4

Work Order ID 102114***102114***

Page 2

Monday, May 27, 2013 10:02:35 AM

Item ID: D4027-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Hose Clamp Assembly

Stop ***NS2***

Start Date: 5/27/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/31/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

13/5/29
MF
13-5-29

Picklist Print

Monday, May 27, 2013 10:02:32 AM

Page 1

Work Order ID: 102114
Parent Item: D4027-043
Parent Item Name: Hose Clamp Assembly

Start Date: 5/27/2013

Required Date: 5/31/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.02.01 new issue Prelim EC verified by:JLM IPP Rev:B 10.05.17 as per ECN10-562 DD verf:EC IPP Rev:C 11.08.04 was MS21042L09 is 06 (nut) DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4027-3 Hose Clamp		Manufactured	No			100	Each	10.0000	1	4		FF 13-05-28	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST450		10							
				100254		10							
X D4027-3 Rubber Cushion		Manufactured	No			100	Each	12.0000	1	4		FF 13-05-28	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		12							
				67814		1							
				83970		11							
AN743-13 BRACKET		Purchased	No			100	Each	16.0000	1	4		FF 13-05-28	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST347		16							
				121825		6							
				123352		10							
NAS1149DN632J Washer		Purchased	No			100	Each	214.0000	1	4		FF 13-05-28	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST293		21							
				123900		21							
				ST510a		193							
				125646		193							

Picklist Print

Monday, May 27, 2013 10:02:33 AM

Page 2

Work Order ID: 102114

Parent Item: D4027-043

Parent Item Name: Hose Clamp Assembly

Start Date: 5/27/2013

Required Date: 5/31/2013

Start Qty: 4.00

Required Qty: 4.00

MS24693-S28

Purchased

No

100

Each

111.0000

1

4

Screw

FF 13-05-28

Location

Loc Qty

Loc Code

ST301

10

4824

10

ST302

101

11334

60

8170

41

4

MS21042L06

Purchased

No

100

Each

601.0000

1

4

Nut

FF 13-05-28

Location

Loc Qty

Loc Code

ST314

101

124859

101

ST316

500

125303

500

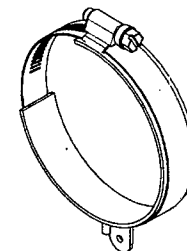
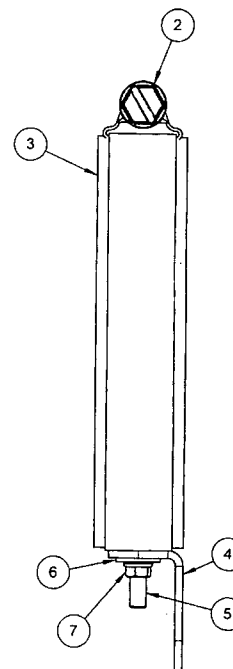
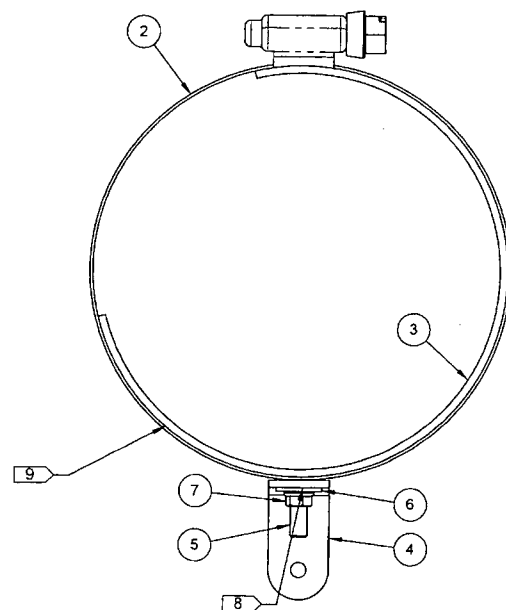
4

Monday, May 27, 2013 10:02:33 AM

Shop Packet Print

Page 2

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-041	VENT CLAMP ASSEMBLY	JCA-M47-2-20
2	1	D4027-1	HOSE CLAMP	
3	1	D4027-5	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT ANGLE	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	



D4027-041 VENT CLAMP ASSEMBLY

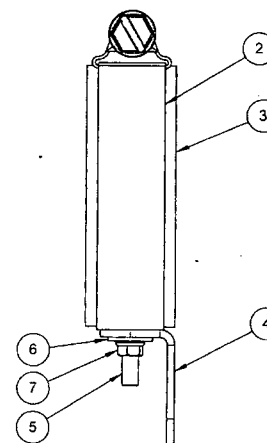
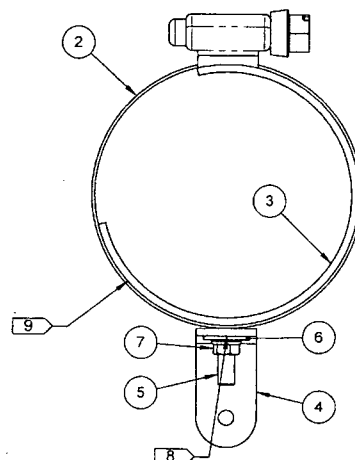
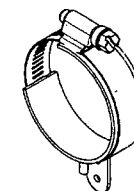
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-5 RUBBER CUSHION TO D4027-1 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

RELEASED
2010-05-05

A	NEW ISSUE			10.04.16
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4027 TITLE CLAMP COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		
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CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.04.16			

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-043	VENT CLAMP ASSEMBLY	JCA-M47-2-35
2	1	D4027-3	HOSE CLAMP	
3	1	D4027-5	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT CLAMP	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	



D4027-043 VENT CLAMP ASSEMBLY

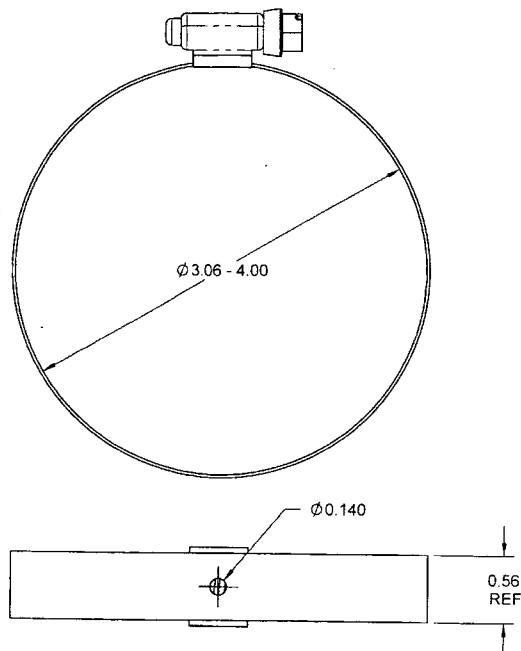
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2010-05-05
NW

NOTES:

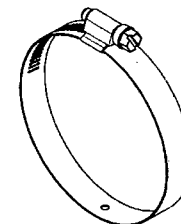
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-7 RUBBER CUSHION TO D4027-3 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

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APPROVED		SCALE	NTS
DE APPR.			
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-1	REF JCA-M47-2-20



D4027-1 HOSE CLAMP



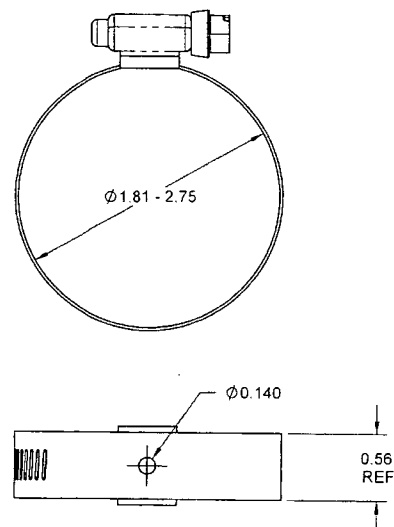
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- 1) MATERIAL: MADE FROM QS200M56S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL Ø 0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

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2010-05-15

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-3	REF JCA-M47-2-35



D4027-3 HOSE CLAMP

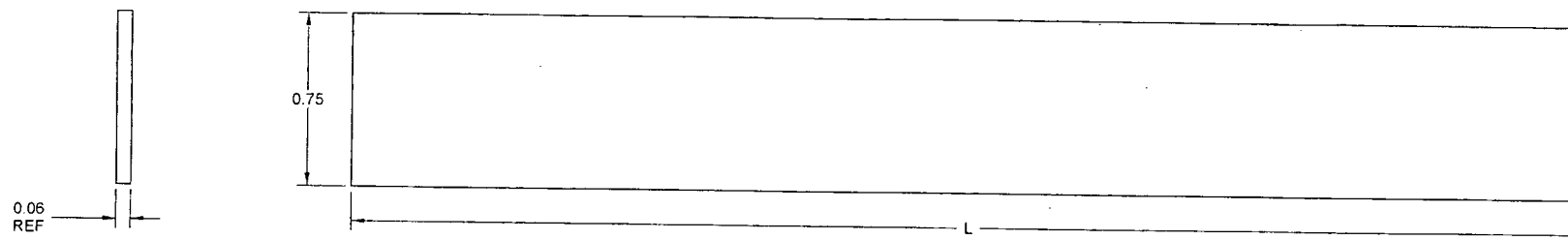
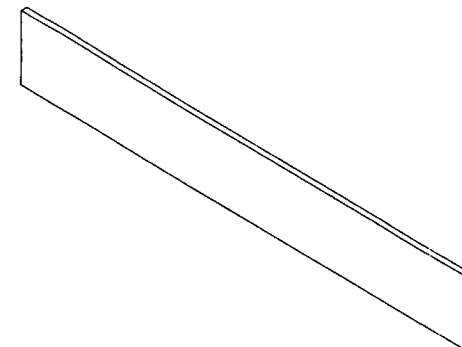
RELEASED
2010-05-05
WDS

NOTES:

- 1) MATERIAL: MADE FROM QS200M36S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL Ø0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-5	REF JCA-M47-2-20
D4027-7	REF JCA-M47-2-35



DART PART NUMBER	LENGTH "L"
D4027-5	5.30
D4027-7	8.25

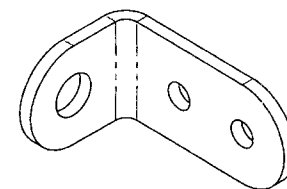
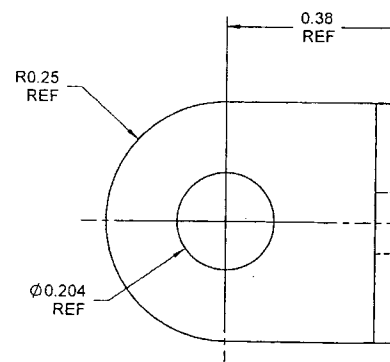
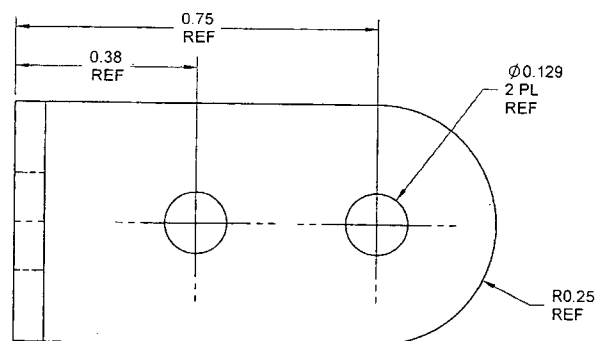
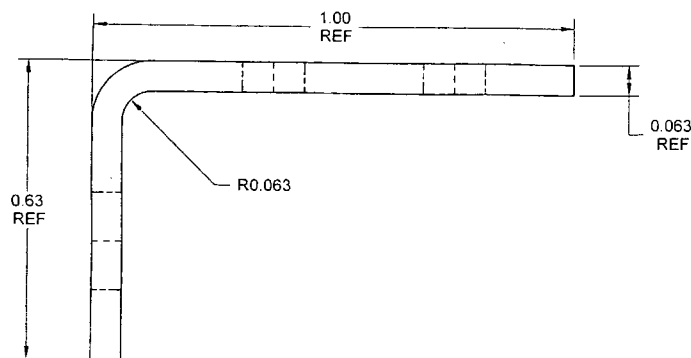
D4027-X RUBBER CUSHION

RELEASED
R 2010-05-05
MP

- NOTES:**
- 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK
REF DART SPEC M-NEO-60-S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-9	REF JCA-M47-2-20/-35



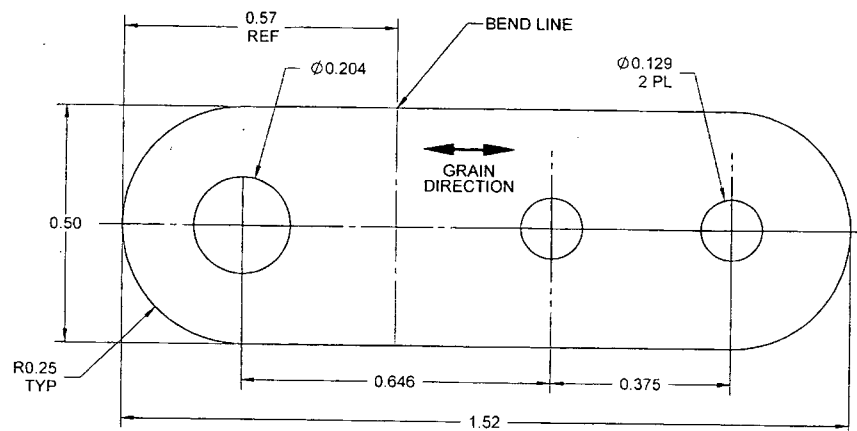
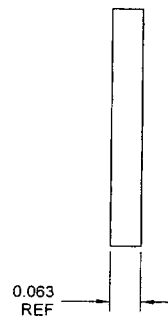
D4027-9 BRACKET, SUPPORT ANGLE

RELEASED
2010-05-05
MD

NOTES:

- 1) MATERIAL: MADE FROM D4027-9F OR EQUIVALENT TO AN743-C13
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4027	REV. A
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D4027-9F FLAT PATTERN

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 THICK
PER AMS5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

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